

**Work Order ID 77550**

December-13-11 1:40:32 PM

**\*77550\***

Page 1

Item ID: D3891-042

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Panel, Fwd RH

Stop **\*NS2\***

Start Date: 13/12/2011 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 28/12/2011 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan: M.C.JDate: 11/12/13 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3891	A

100

0.00

**\*100\***

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3891-2

Dwg Rev: AProg Rev: A

2-Deburr if necessary

B12-1-5(2)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

B12-1-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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**NOTE:** Date & initial all entries

**Work Order ID 77550****\*77550\***

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Item ID: D3891-042

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Panel, Fwd RH

Stop **\*NS2\***

Start Date: 13/12/2011 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 28/12/2011 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

0.00

**\*150\***

Small Fab

Memo

0.00

Small Fab

1- Bond gasket to smooth side of panel as per dwg  
A/R 3M 1300 adhesive Batch: 1119597

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

Memo

0.00

Quality Control

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 77550****\*77550\***

Page 4

Item ID: D3891-042

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Panel, Fwd RH

Stop **\*NS2\***

Start Date: 13/12/2011 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 28/12/2011 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

12/11/11  
MK  
12-01-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

December-13-11 1:40:37 PM

Page 1

Work Order ID: 77550

\*77550\*

Parent Item: D3891-042

\*D3891-042\*

Parent Item Name: Panel, Fwd RH

Start Date: 13/12/2011

Required Date: 28/12/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	2,890.665	3.8097	8.020421			

\*MI FXS 125-F60029-04\*

GE PLASTICS LEXAN SHEET

\*\*

B12-1-5

(2)

Location

Loc Qty

Loc Code

MAT018

2890.665

115261

234.665

119937

2656

115261

Manufactured No

140

Each

1.0000

1

2

\*\*

D3891-4

\*D3891-4\*

Gasket

Location

Loc Qty

Loc Code

GA

1

69380

1

ES 12/01/10

B78437

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

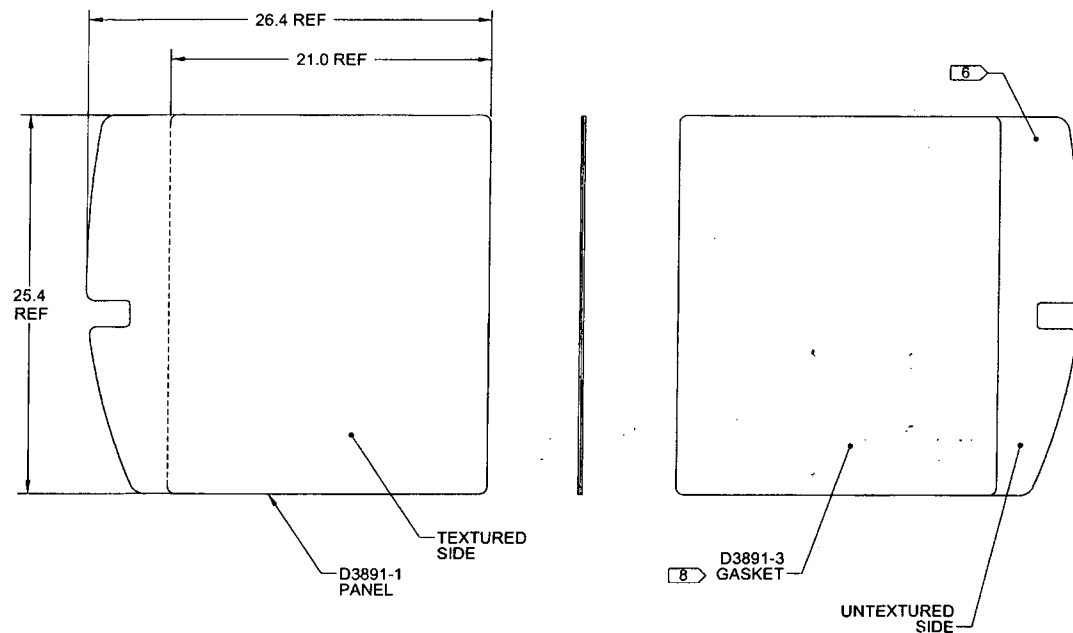
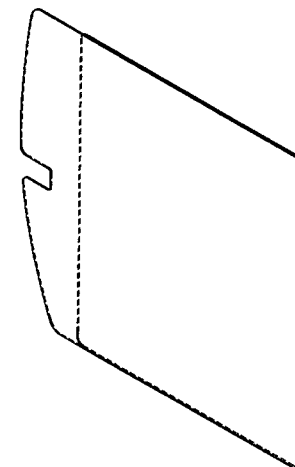
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3891-041	PANEL, FWD LH
2	1	D3891-1	PANEL
3	1	D3891-3	GASKET
4	A/R	3M 1300	ADHESIVE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 77550 H.L.J  
11/12/13



**D3891-041 PANEL, FWD LH**

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 3.67 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

RELEASED  
C9/08/16 M

A	NEW ISSUE	CP	09.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	92	DRAWING NO.	REV. A
CHECKED	92	D3891	SHEET 1 OF 6
MFG. APPR.	92	TITLE	SCALE
APPROVED	92	PANEL, FWD	NTS
DE APPR.	92	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.05.01		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

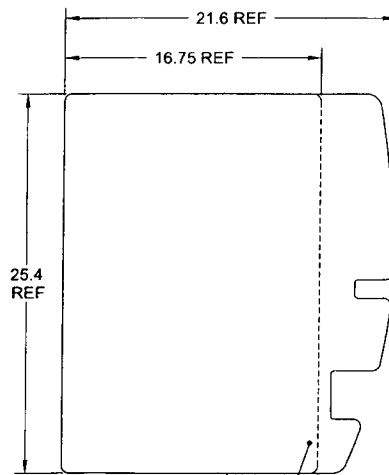
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

77550

**PARTS LIST**

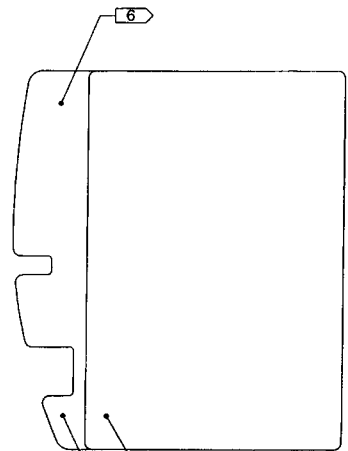
ITEM	QTY	P/N	DESCRIPTION
1	X	D3891-042	PANEL, FWD RH
2	1	D3891-2	PANEL
3	1	D3891-4	GASKET
4	A/R	3M 1300	ADHESIVE



D3891-2 PANEL

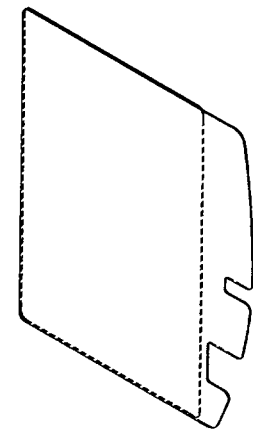
TEXTURED SIDE

**D3891-042 PANEL, FWD RH**



D3891-4 GASKET 6

UNTEXTURED  
SIDE



**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3891-042" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 2.93 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED.

**RELEASED**  
C9/D/H/W

DESIGN	92	<b>DART AEROSPACE LTD</b>	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	92	D3891	SHEET 2 OF 6
APPROVED	92	TITLE	SCALE
DE APPR.	92	PANEL, FWD	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

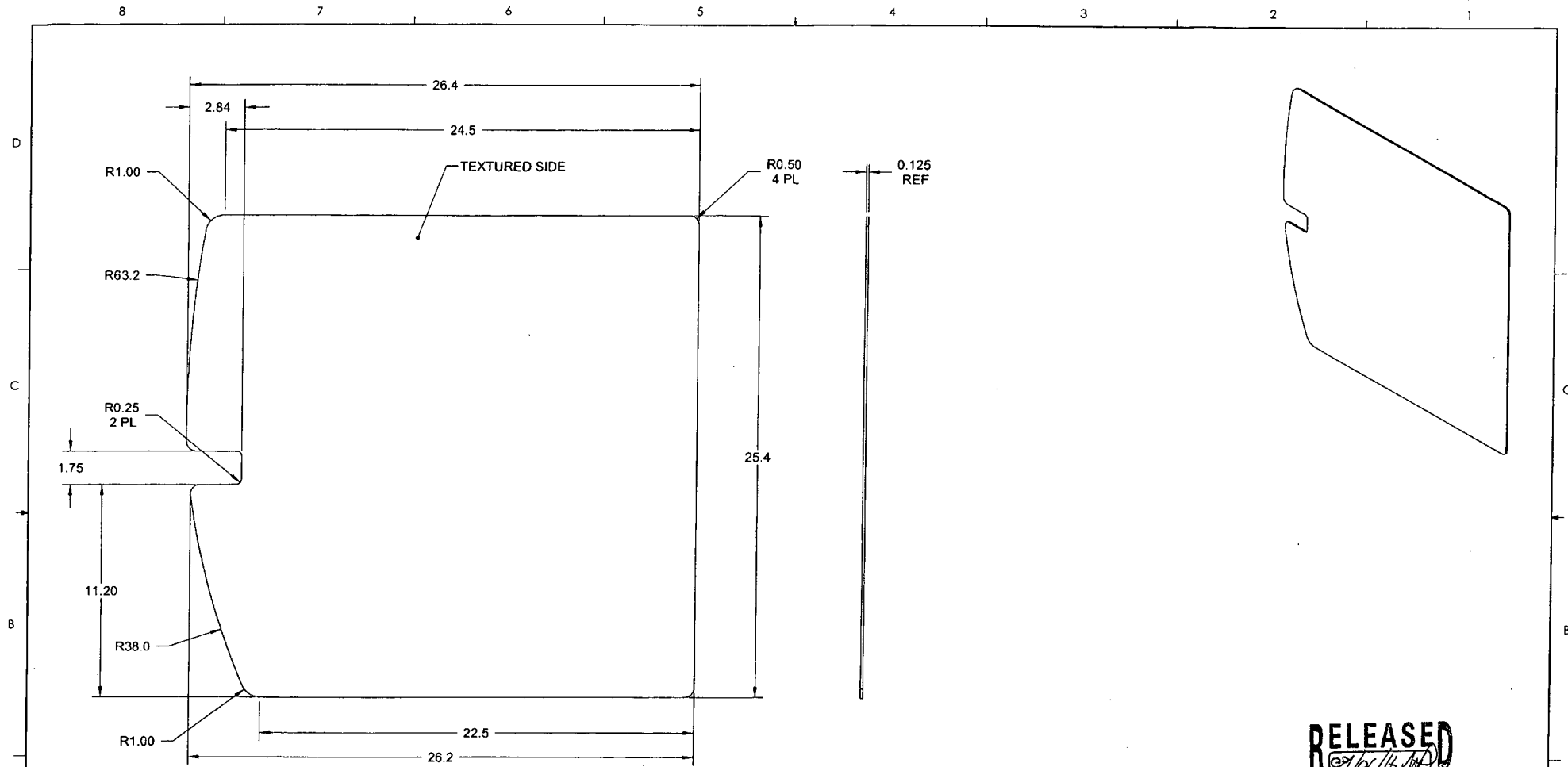
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



77550



**D3891-1 PANEL**

**RELEASED**  
09/05/01

**NOTES:**

- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 3.46 lbs

DESIGN	DP	<b>DART AEROSPACE LTD</b>	
DRAWN	DP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DP	DRAWING NO.	REV. A
MFG. APPR.	DP	D3891	SHEET 3 OF 6
APPROVED	DP	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

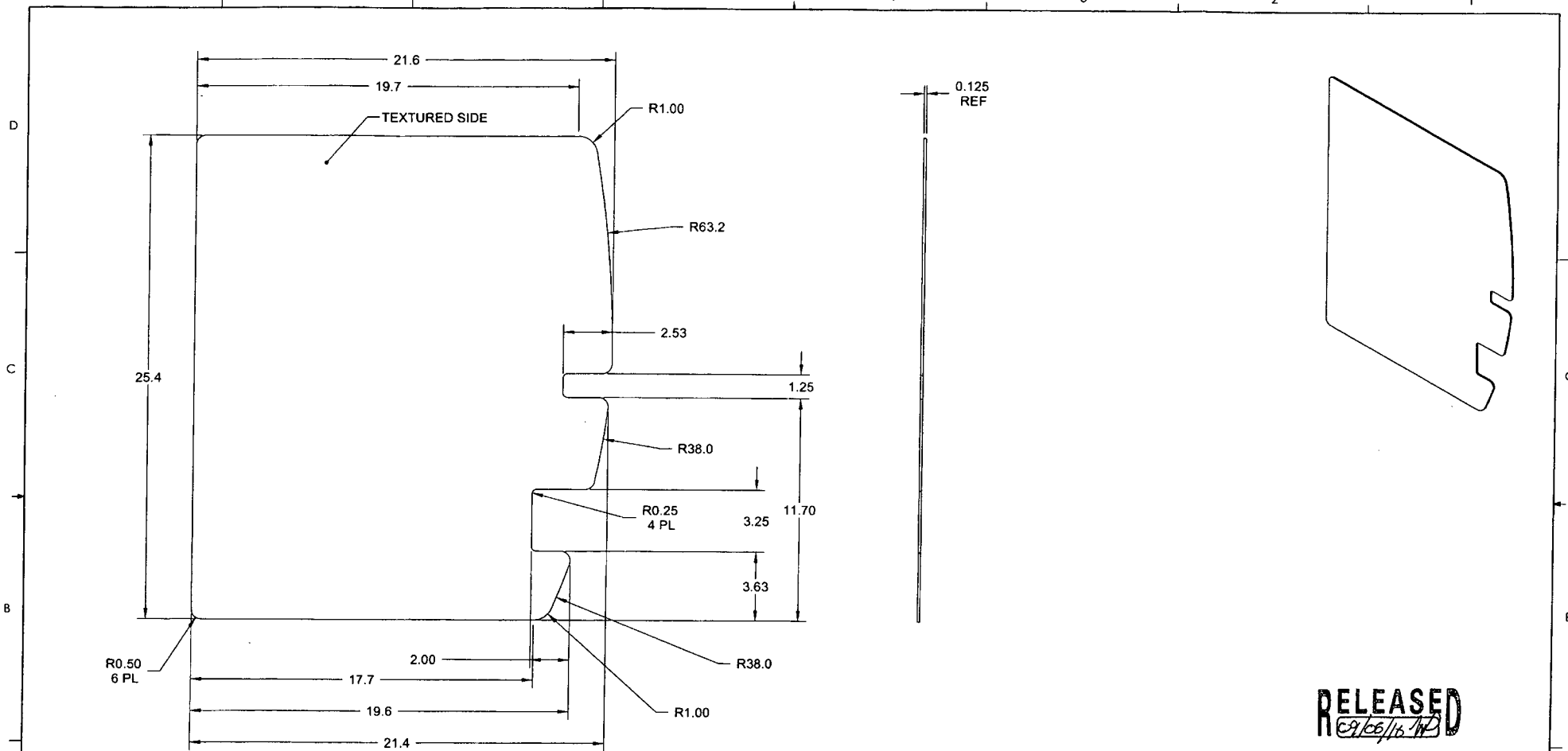
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**NOTE:** Date & initial all entries

77550



**D3891-2 PANEL**

**NOTES:**

- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.77 lbs

**RELEASED**  
09/05/01

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3891	SHEET 4 OF 6
APPROVED		TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
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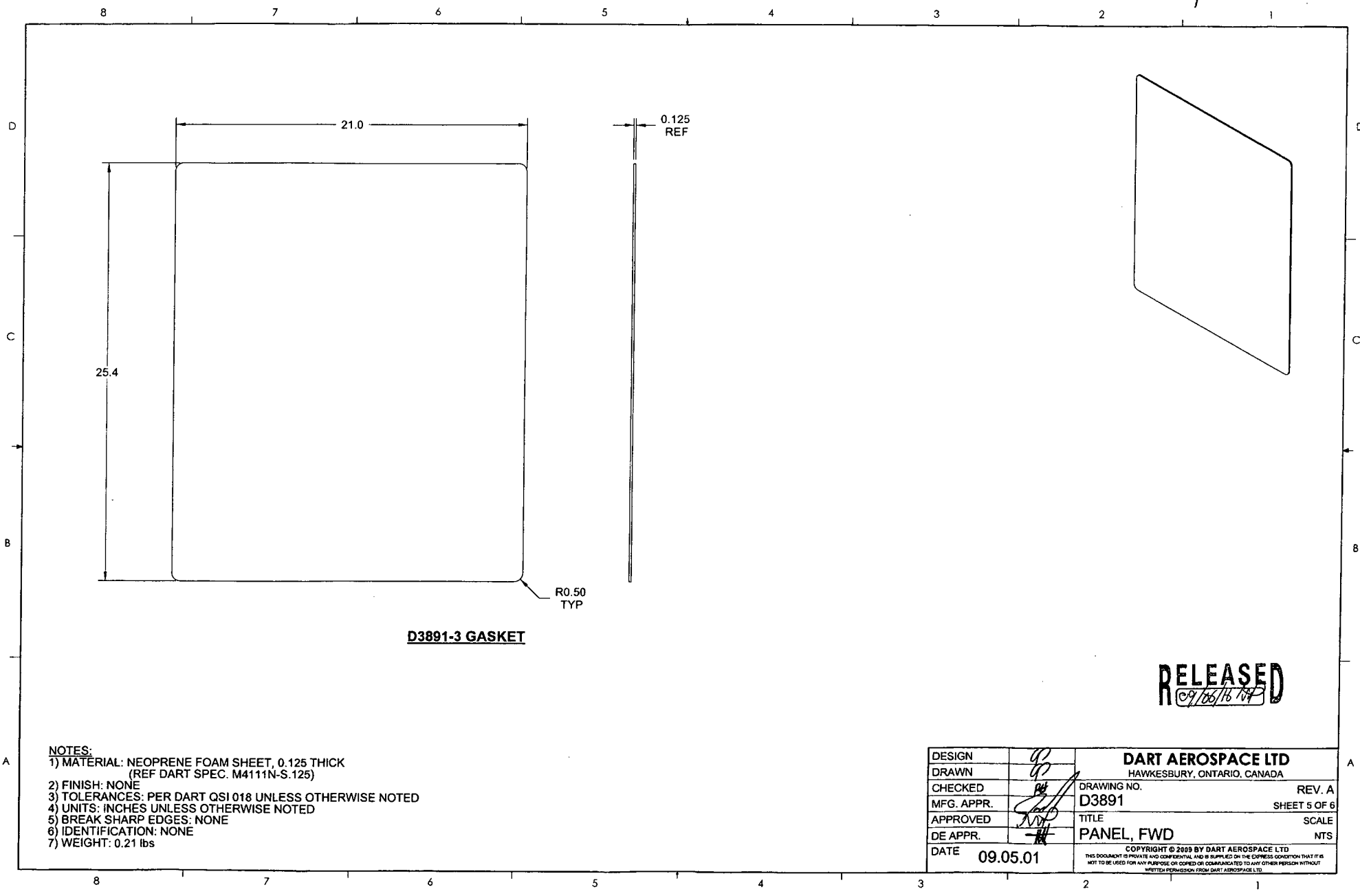
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**NOTE:** Date & initial all entries

77550



**D3891-3 GASKET**

**RELEASED**  
09/06/16

**NOTES:**

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK  
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.21 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN	<i>GP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>GP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>GP</i>	D3891	SHEET 5 OF 6
APPROVED	<i>GP</i>	TITLE	SCALE
DE APPR.	<i>GP</i>	PANEL, FWD	NTS
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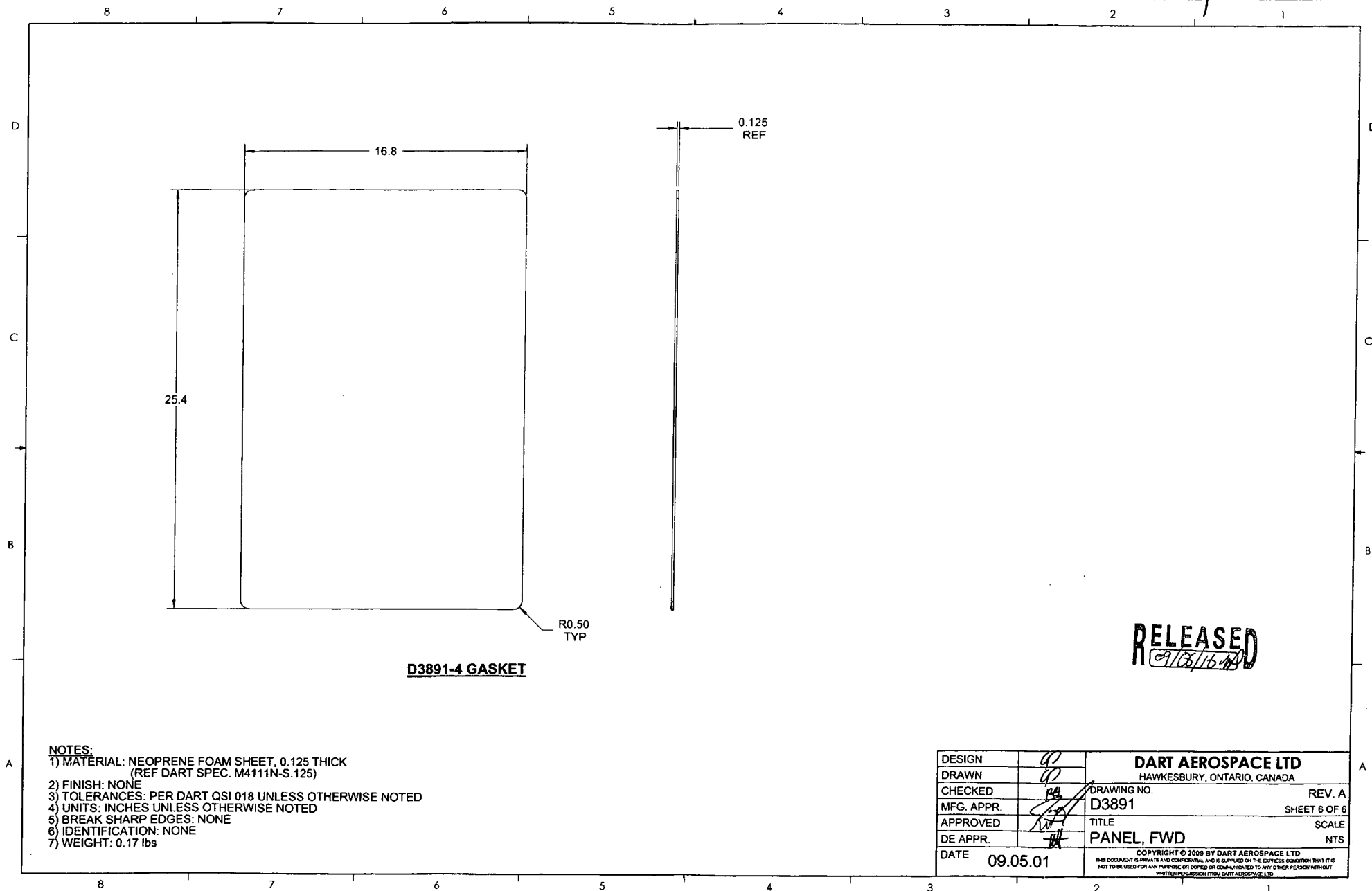
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77550



**D3891-4 GASKET**

**RELEASED**  
09/05/01

**NOTES:**

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK  
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.17 lbs

DESIGN	GP	<b>DART AEROSPACE LTD</b>	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. A
MFG. APPR.	GP	D3891	SHEET 6 OF 6
APPROVED	GP	TITLE	SCALE
DE APPR.	GP	PANEL, FWD	NTS
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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